

Date: Tuesday, 5/16/2006 10:40:42 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 155 BRACKET
Job Number : 27142	
Estimate Number : 11040	
P.O. Number : N/A	Part Number : D28042
This Issue : 5/16/2006 S.O. No. : N/A	Drawing Number : D2804 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 26645	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 5/30/2006 Qty: 10 Um: Each
Checked & Approved By : <u>06.05.16</u>	
Comment : Est. A0011.06 New Issue EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0500X12000

6061-T6 Bar .50" x 12.0"



Comment: Qty.: 0.7875 f(s)/Unit Total : 7.8750 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: M100817

MS 06/05/25

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks per template DT8534

SA 06.03.30

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

SA 06.05.30

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.05.30

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/06/02

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

J.F. 06/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/08

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/16/2006 10:40:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 27142

Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



06-06-05

(6)

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06-06-07

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST159

06/6/7

(9)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/08

(10)

Job Completion



06-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27142
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.125	/			
0.125	+/-0.010	.121	/			
R0.125	+/-0.010	R.125	/			
0.250	+/-0.010	.251	/			
0.250	+0.000/-0.005	.255	/			
0.875	+0.000/-0.001	.875	/			
R0.062	+/-0.010	R.063	/			
Ø0.757	+0.005/-0.000	Ø.757	/			
R0.625	+/-0.010	R.625	/			
12.304	+/-0.005	12.304	/			
Ø0.507	+0.000/-0.001	Ø.5065	/			
0.437	+0.000/-0.001					
0.608	+0.000/-0.001					
Ø0.191	+0.005/-0.000	Ø.191	/			
1.420	+0.001/-0.001	1.420	/			
0.250 deep	+/-0.010	.246	/			
6.933	+/-0.005	6.933	/			
7.578	+/-0.005	7.578	/			
0.500	+/-0.010	.500	/			Mat thickness

Measured by: SD	Audited by: J.E.	Prototype Approval:	N/A
Date: 06.05.30	Date: 06/05/30	Date:	N/A

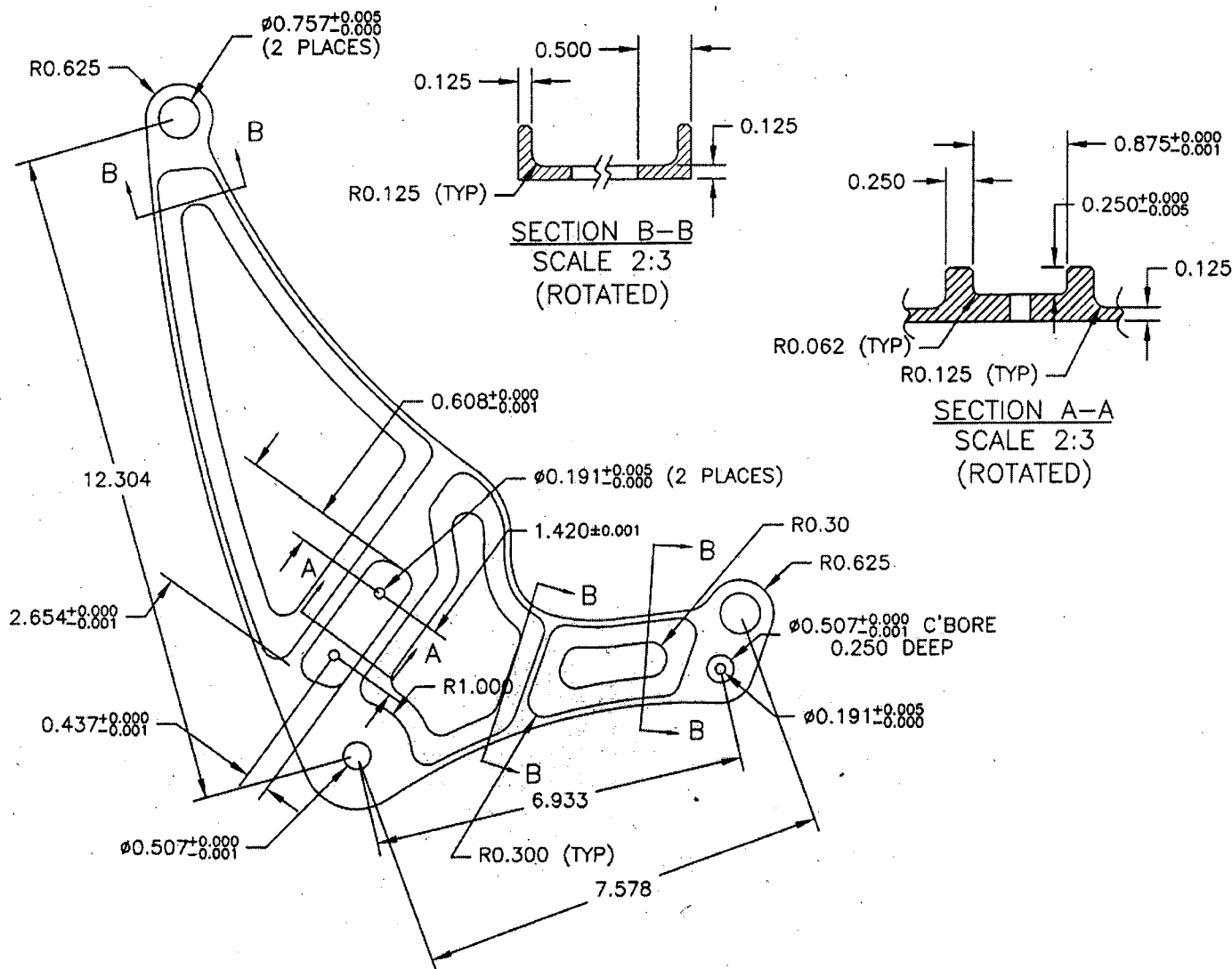
Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 1 OF 2
				D2804	
DATE	04.11.22			TITLE	SCALE
				STA 155 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED

05-03-11

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804.SLDPR" (THICK)
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

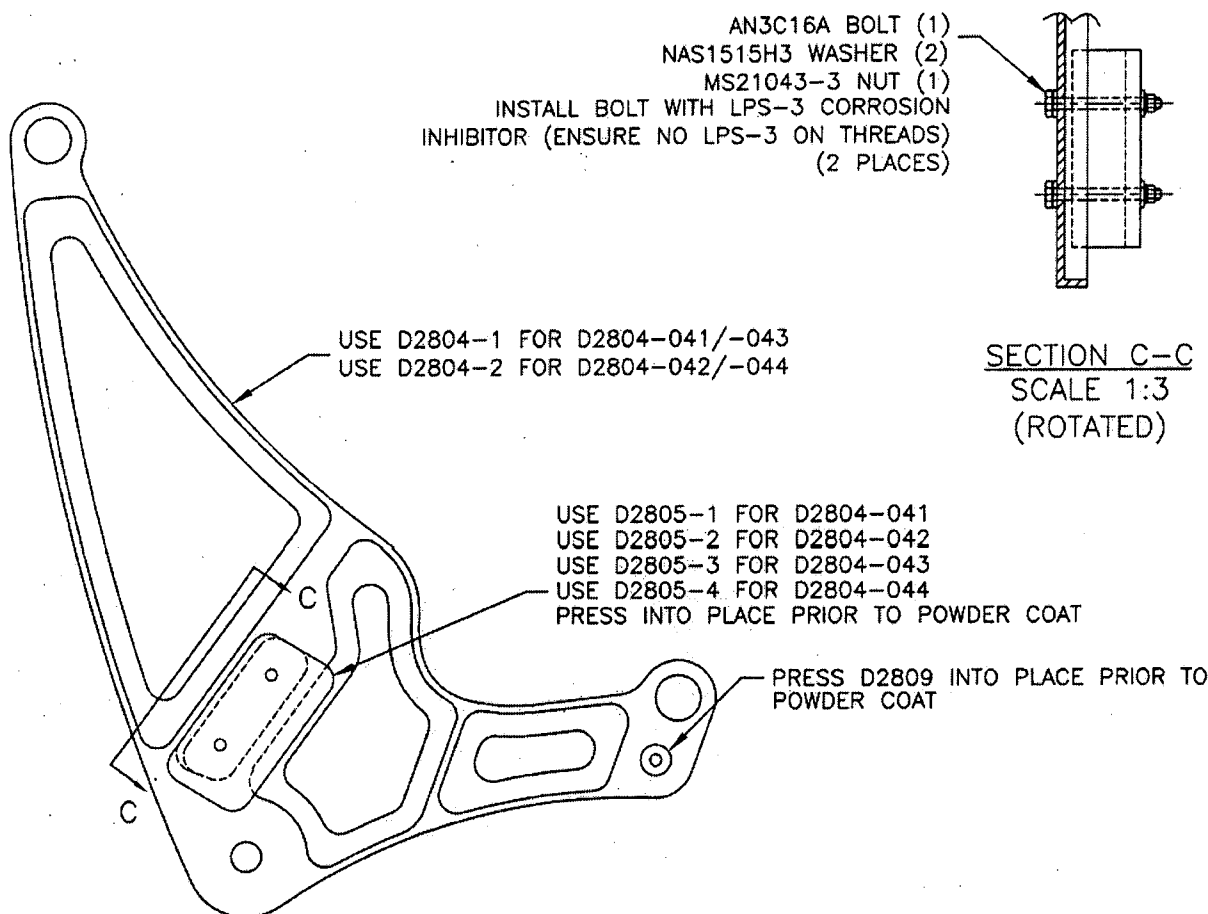
NO. 27142

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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	SHEET 2 OF 2
				D2804	
DATE	04.11.22	TITLE	STA 155 BRACKET	SCALE	1:3



RELEASED

05-03-11

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WORK ORDER

NO.

D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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